Work O	rder	ID	58643
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Wednesday, May 12, 2010 1:48:24 PM



Page 1

Item ID:

D3684-045

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

LEG ASSEMBLY

5/13/2010

Start Qty: 3.00

Req'd Qty: 3.00



Cust Item ID: Customer:

Run

Start



Reference:

Approvals: QC:

Process Plan: VMF

Date: 10-5 - 12 Tooling:

Date:

Date:

Date:

Stop

Sequence-ID/ **Work Center ID** Draw Nor

Required Date: 5/21/2010

Description **Revision Nbr**

Pick Kit

Operation

Set Up/ **Run Hours** Draw Number

Draw Plan Rev. Code

Accept Reject Qty Oty

Reject Number

Insp. Stamp

D3684

Rev D

0.00

SPC (Y/N):

Packaging

Packaging

Memo

Memo

0.00

SB 10/06/23 3

110

100

Small Fab

0.00

Small Fab

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivelent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

ensure holes AN3C bolts are clear of sealant

Sp 10/06/23

Dart Aerospa	ce Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			-					-	
Part No	·	PAR #:	Fault Cate	gory:	NCR: Ye	s No DQ	A:	Date: _	
	Rese	olution:	Dispositio	n:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NO	R)			
DATE	STEP	Description of NC	1.44.1	on B	Verifi	cation			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ion C	Chief Eng	QC Inspector
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Work Order ID 58643

Wednesday, May 12, 2010 1:48:24 PM



Page 2

Item ID:

D3684-045

Accept



Setup Start

Stop



Revision ID:

Item Name:

LEG ASSEMBLY

Start Date:

5/13/2010

Start Qty: 3.00

Required Date: 5/21/2010

Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Date: _____

Tooling: SPC (Y/N):

0.00

Date: Date:

Run

Start Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: 1390

Set Up/ **Run Hours**

Draw Number

Draw Rev.

Plan Code

Reject Accept Qty Qty

Reject Number Stamp

Insp.

Memo

130

Packaging Packaging

Memo

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

0.00

10/06/24 Hy CX10/6/24

Dart Aerospace Ltd

W/O:			ES								
DATE	STEP	PRO	OCEDURE CH	ANGE	By	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: PAR #: Fault											
	Re	esolution:	Dispositi	on:	_ QA: N/0	Clos	sed:		Date: _		
NCR:		1	WORK ORE	DER NON-CONFORMA	ANCE (N	CR)					
DATE	STEP	Description of NC Section A Initial Action Description			ion B	Verification		Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		gn & ate	Section	n C	Chief Eng	QC Inspector	
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Picklist Prin	t						<u> </u>		
Wednesday, May		23 PM							Page 1
Work Order ID:	58643								
Parent Item:	D3684-045								
Parent Item Name:	LEG ASSEN	MBLY					Start Date	: 5/13/2010	Required Date: 5/21/2010
Comments:	IPP Rev:B REV:C AS F	new issue 08-02-12 D As per Rev B 09-01-07 J PER REV D 10-03-16 JLJ Added sealant note as per	LM Veri M Veri	rified By:EC IP FIED BY:EC	P d By:DD	1	Start Qty	v: 3.00	Required Qty: 3.00
AN3C12A		Purchased	No		110	Each	104.0000	2	
				<u>Location</u> ST351 112314	<u>L</u>	104 104	Loc Code		_ So abole3
D3688-5		Manufactured	No		110	Each	9.0000	1	
				<u>Location</u> ST081 46054	<u>L</u>	9 9	Loc Code	- 3	- SA 10/01/23
D3689-1		Manufactured	No		110	Each	16.0000	1	
5222.2				Location ST082 B 5 8 6 3	ન <u>L</u>	16	Loc Code	3	- St 18/06/23
D3691-1	111	Manufactured	No	56335	110	5 Each	1.0000	1	

Loc Oty

Loc Code

Location

54859 B58634B68631

ST082

3 St Now 27

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	FS				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #: Fault Car				gory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	າ:	QA: N/C CI	osed:		Date:	
NCR:	:		WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A Corrective Action Section Action Description					cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, May 12, 2010 1:48:23 PM

Page 2

Work Order ID: 58643

Parent Item:

D3684-045



Location

50736

51467

ST082

Location

Parent Item Name:

LEG ASSEMBLY

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:JLM

IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM

IPP

Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Required Qty: 3.00

D3692-1

Manufactured

No

110

Each

Loc Qty

Each

521.0000

4

Start Qty: 3.00

	1110 BASIN (811)	
SPACER		

D3693-1

Manufactured No

521 113 408

110

63.0000

Loc Code

Sp (0)06/23

Rod End Bearing

MS21043-3

Purchased

Purchased

No

Location Loc Oty ST082 63 50734 63 110 Each

Loc Qty

Loc Oty

69

69

Loc Code

3,635.000

So 10/06/23

Loc Code

FG 80 103691 80 ST301 3555 112314 3555 110 Each

69.0000

Se 14/66 (27

No

Location ST280 112453 Loc Code

NAS509-12C

Nut

Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	iES					
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE S	STEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Verification Section C		Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, May 12, 2010 1:48:23 PM

Work Order ID: 58643

Parent Item:

D3684-045

Parent Item Name:

LEG ASSEMBLY

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:JLM

IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM

IPP

Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Page 3

Start Qty: 3.00

Required Qty: 3.00

NAS509L12C

Purchased

No

110

Each

74.0000

Nuts	

<u>Location</u>	Loc Oty
ST280	74
112314	64
112828	10

Loc Code

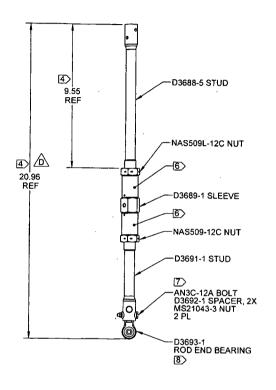
3 Sb 10/04/23

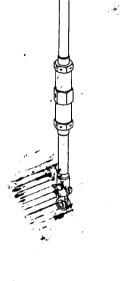
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W/O:			W	ORK ORDER CHANGE	ES							
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	·:	_ Date: _				
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NCR:			WORK ORI	DER NON-CONFORMAN	ICE (NC	R)	<u>-</u>					
DATE	STEP	Description of NC				Verific	ation	Approval	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector			
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7 QTY -045 ITEM PART NUMBER DESCRIPTION 1 D3684-045 INBOARD LEG ASSEMBLY D3688-5 STUD 3 D3689-1 SLEEVE 4 D3691-1 STUD D3692-1 SPACER 6 D3693-1 ROD END BEARING AN3C-12A BOLT MS21043-3 NUT 9 NAS509L-12C NUT 10 NAS509-12C NUT

8





D3684-045 INBOARD LEG ASSEMBLY

NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED
3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045
USING FINE POINT PERMANENT INK MARKER
4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

5) WEIGHT: 3.1 lbs

8

5) WEIGHT. 3. HIS 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD 7) TORQUE FASTENERS TO 20-25 in-lbs 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN RF DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. D D3684 MFG. APPR SHEET 3 OF 5 APPROVED TITLE SCALE TRIPOD MOUNT ASSY DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
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W/O:			W	ORK ORDER CHANG	GES					
DATE STEP		PROCEDURE CHANGE			. ;	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	tegory:	NC	R: Yes	No DQ	A:	Date:	
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NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			Verific	cation Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	k Secti	on C	Chief Eng	QC Inspector
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